

Date: Thursday, 12/20/2007 3:17:28 PM
 User: Kim Johnston

Process Sheet

3

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MIRROR BRACKET RH
 Job Number : 36467A02
 Estimate Number : 10147
 P.O. Number : N/A Part Number : D20132
 This Issue : 12/20/2007 S.O. No. : N/A Drawing Number : D2013 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : C
 Previous Run : 28218A02 Material : N/A
 Due Date : 1/15/2008 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : 12/21
 Comment : Est Rev: A New Issue 05-11-01 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0750W049 304 RD Tube .750 x .049W



Comment: Qty.: 2.0447 f(s)/Unit Total : 8.1787 f(s)
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing
 (M304TR0.750W.049)
 Batch: M106015

FF 08-01-10
~~10-01-08~~ (4)

2.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

- 1-Punch as per template D2013-T1 and Dwg D2013
- 2-Flatten ends of D2013-2 tube as per Dwg D2013 using DT8545
- 3-Bend (1) tube as per Dwg D2013 using Jig DT8201 identify as D2013-2.
- 4-Deburr as required

FF 08-01-10
~~10-01-08~~ (4)
 FF 08-01-14
~~14-01-08~~ (4)
 FF 08-01-15
~~08-01-14~~ (4)
 FF ~~14-01-08~~ (4)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/15 (4)

4.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/16 (4)

Job Completion



PACKAGING

241A

8/1/15 SD

08-01-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

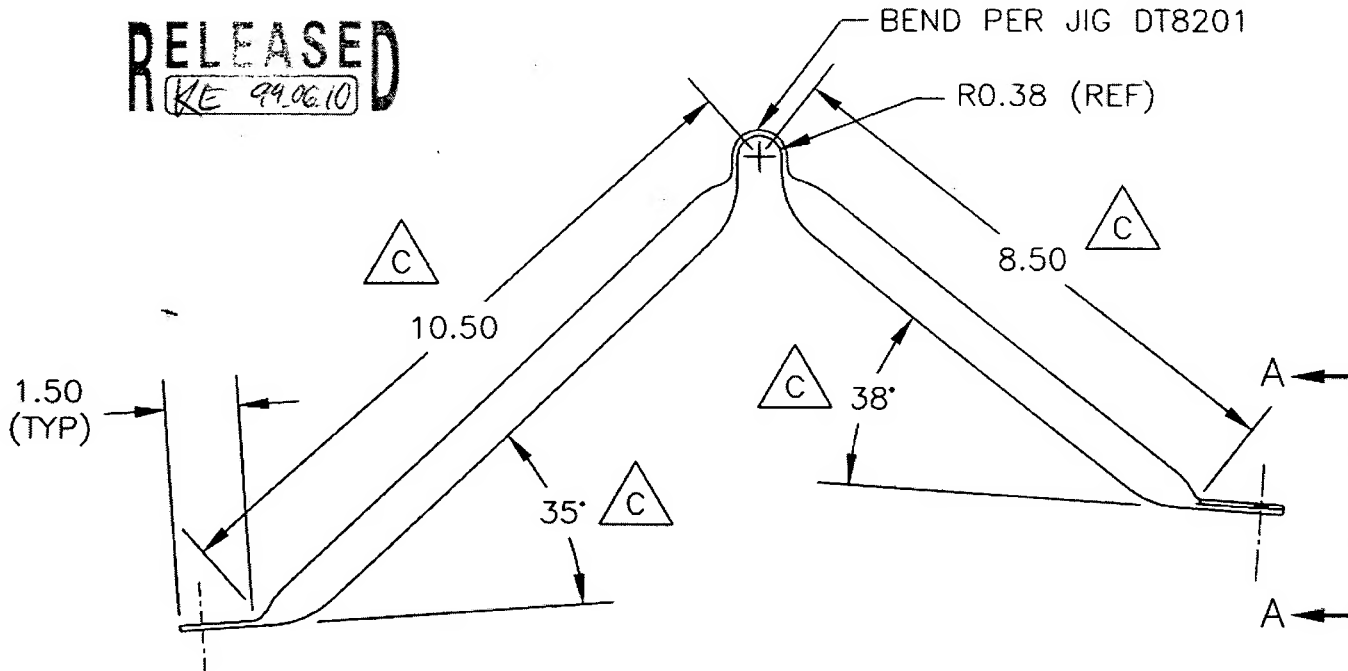
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/01/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

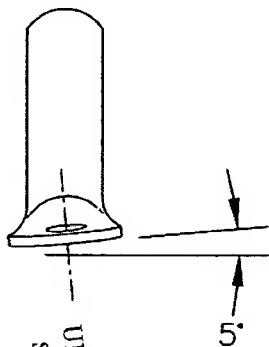
RELEASED
KE 99.06.10

DART



D2013-1 LH SHOWN
D2013-2 RH OPPOSITE
(FOR 205 MIRROR)

DRILL $\varnothing 0.257$ (TYP)
0.400 (TYP)



CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
JB	RF	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2013
DATE 99.06.07		REV. C SHEET 1 OF 3
		SCALE N/S
A	90.10.22	MIRROR BRACKET
B	94.06.15	NEW ISSUE
C	99.06.07	REDRAWN
		REDRAWN, CHANGE OF DIMENSIONS

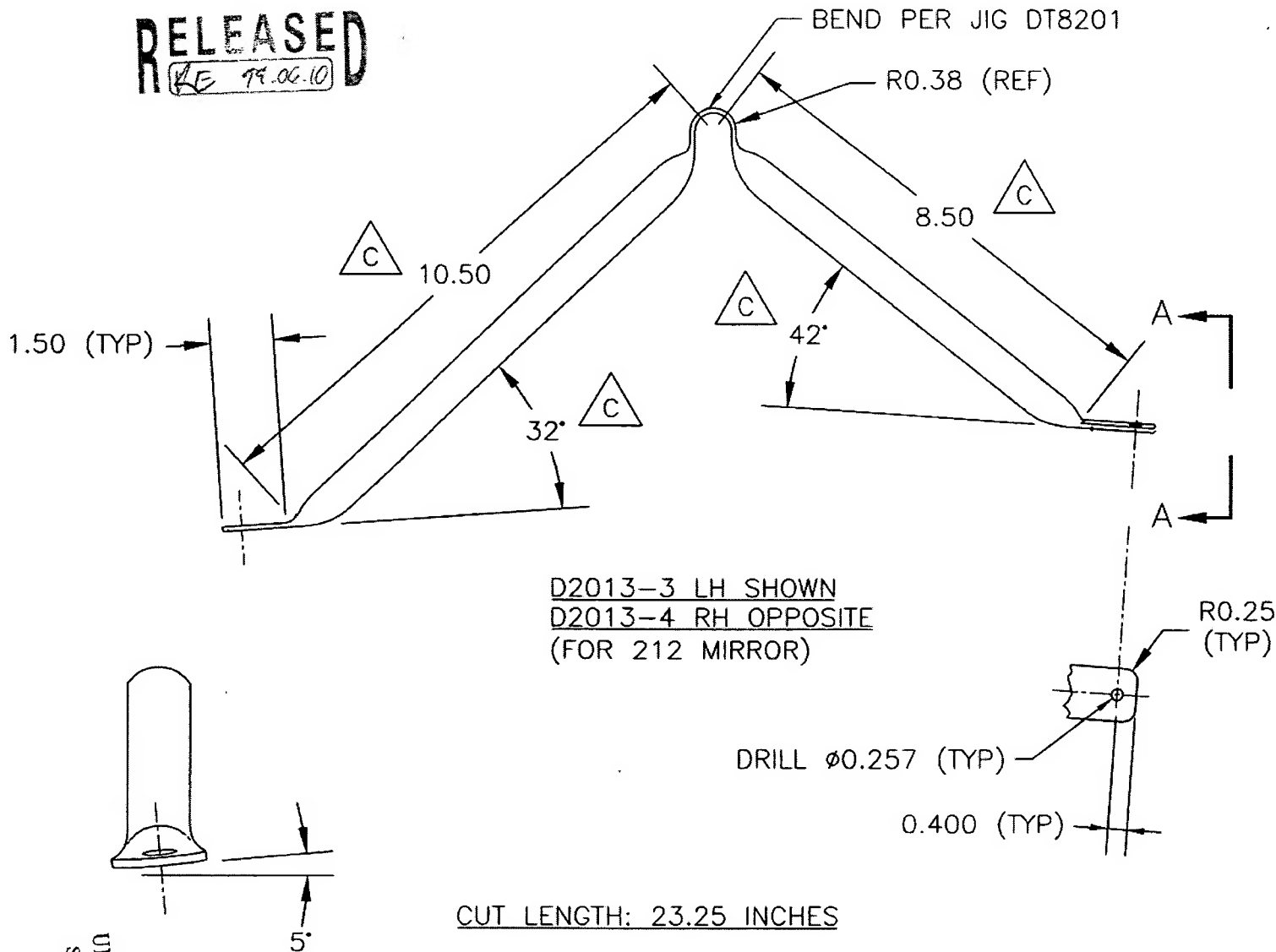
NEW A-A
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
Nette 7402

RELEASED
RE 79.06.10

DART



DESIGN	JB	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	[Signature]	DRAWING NO. D2013
DATE	99.06.07	TITLE	MIRROR BRACKET	REV. C SHEET 2 OF 3
		SCALE	NTS	



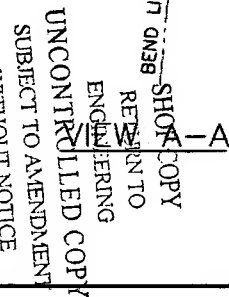
MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO 36467402

KE 99.06.10

INC



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DESIGN	JB	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	KE	APPROVED	DRAWING NO.	REV. C
			D2013	SHEET 3 OF 3
DATE			TITLE	SCALE
99.06.07			MIRROR BRACKET	NTS